

Date: Thursday, 3/16/2006 10:38:25 AM
 User: Kim Johnston




Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLOWER MOTOR ADAPTER
Job Number : 26280	
Estimate Number : 12133	
P.O. Number : N/A	Part Number : D3476043
This Issue : 3/16/2006 S.O. No. : N/A	Drawing Number : D3476 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 3/31/2006 Qty: 1 Um: Each
Checked & Approved By : <u>06.03.16</u>	
Comment : Est Rev:A New Issue 06-01-31 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D34763	blower motor adapter
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Qty Part Number Description Batch 1 D3476-3 blower motor adapter <u>025689-1</u> <u>06.03.28</u> ①		
2.0	D34767	TUBE
 		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Qty Part Number Description Batch 2 D3476-7 Tube <u>B26300</u> <u>06.03.28</u> ②		
3.0	D34761	duct
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Qty Part Number Description Batch 1 D3476-1 Duct <u>B26301</u> <u>06.03.28</u> ①		
4.0	NAS1031C3W	Nutplate
 		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Qty Part Number Description Batch 4 NAS-1031C3W Nutplate <u>M19505 / M19651</u> <u>06.03.28</u> ④		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
 		
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Spot Weld Tubes And Nut plates as per Dwg D3476 and Dart QSI 018 <u>06.03.28</u> ①		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 06/13/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/16/2006 10:38:25 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 26280

Part Number: D3476043

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

5 06.03.29

①

7.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: _____
Electro Chemically Polish weldment as per Dwg Dwg D3476
Ensure Certificate of Conformity is attached

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure material certification is attached

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

06.03.29

②

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.03.30

Job Completion



u 06.03.30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

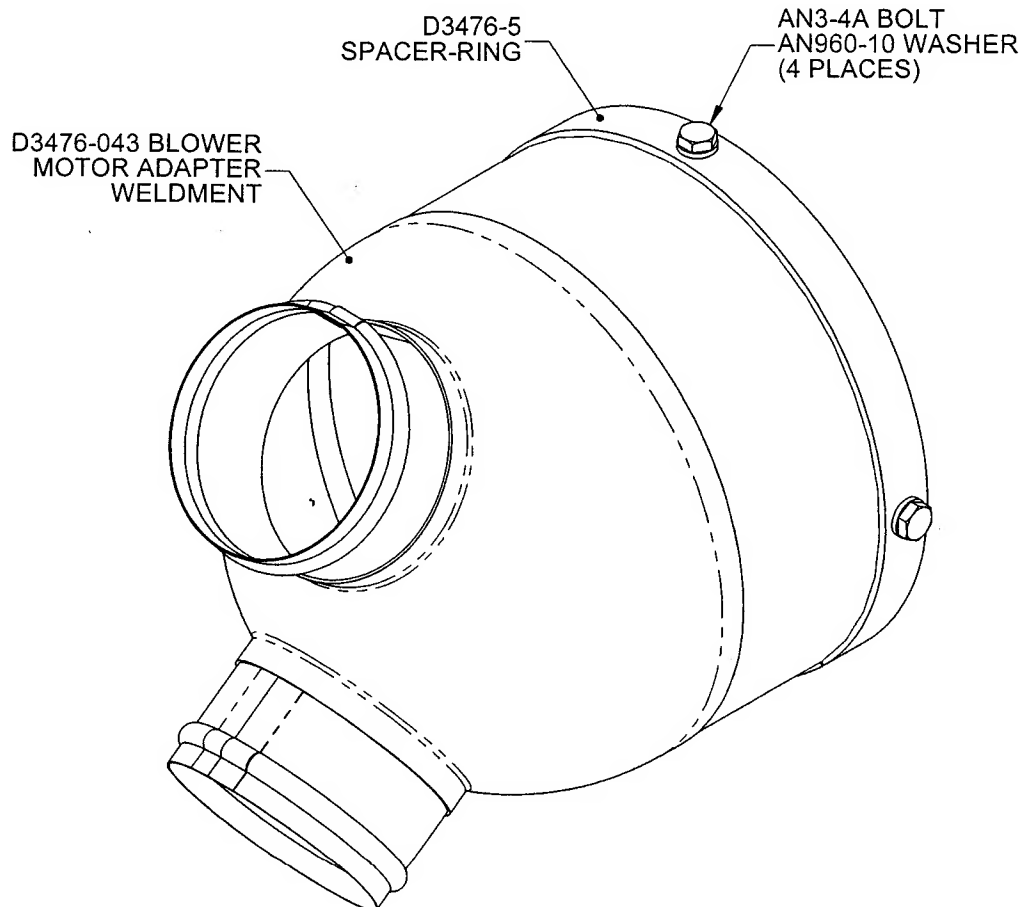
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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CHECKED	APPROVED	DRAWING NO. D3476	REV. A SHEET 1 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER SCALE 1:2	
A	06.01.27	NEW ISSUE	



D3476-041 BLOWER MOTOR ADAPTER



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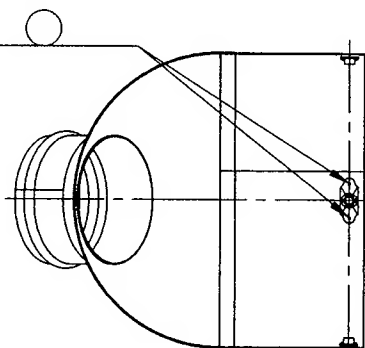
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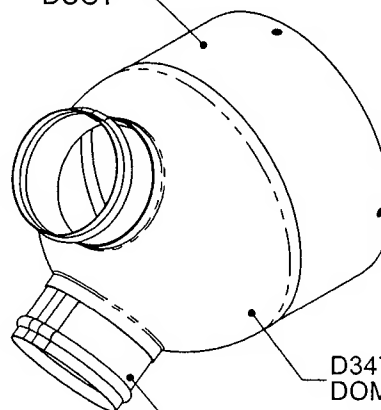
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	
		SCALE 1:4	

LOCATE AND
SPOT WELD
NUT PLATES
(4 PLACES)



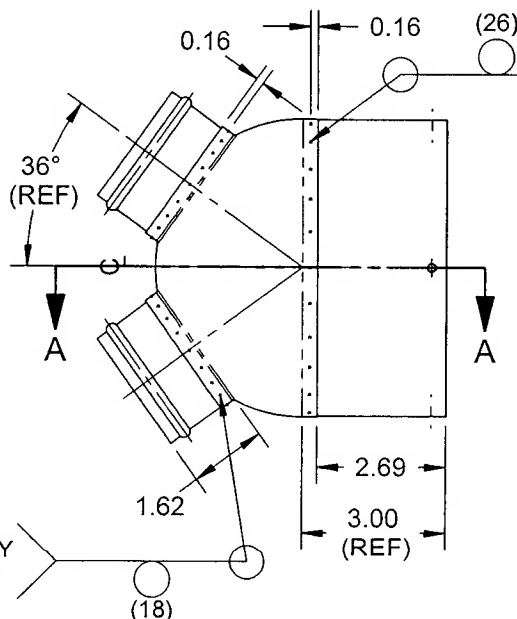
SECTION A-A

D3476-1
DUCT



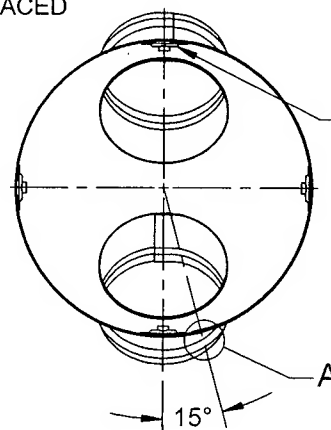
D3476-3
DOME

D3476-7 TUBE
(2 PLACES)



EQUALLY
SPACED

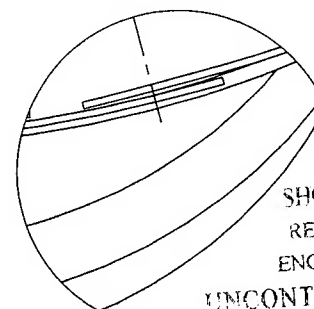
NAS-1031C3W
NUT PLATES
(4 PLACES)



D3476-043 BLOWER MOTOR ADAPTER WELDMENT

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: ELECTRO CHEMICALLY POLISH
- 3) PART IS SYMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010



DETAIL A: OFFSET
SEAM ON DUCT

SCALE 2:1

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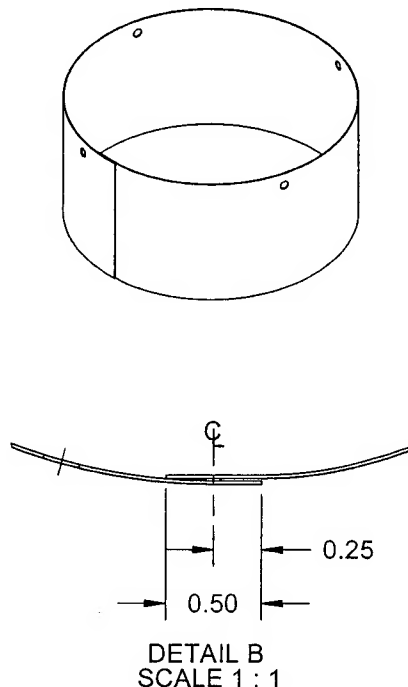
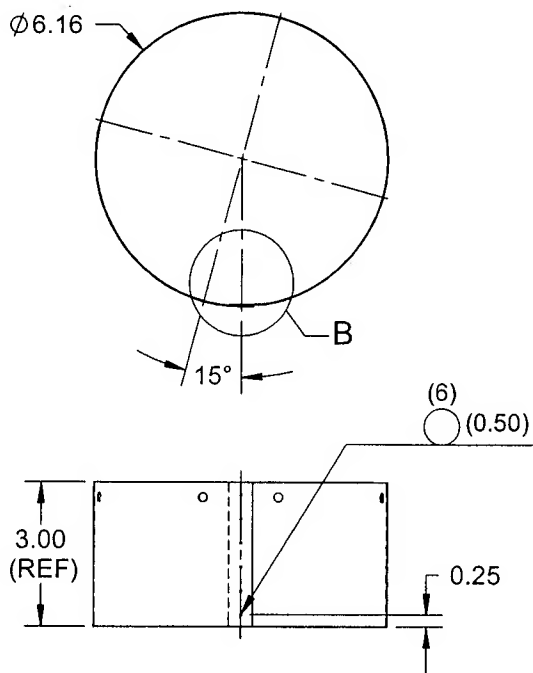
WORK ORDER

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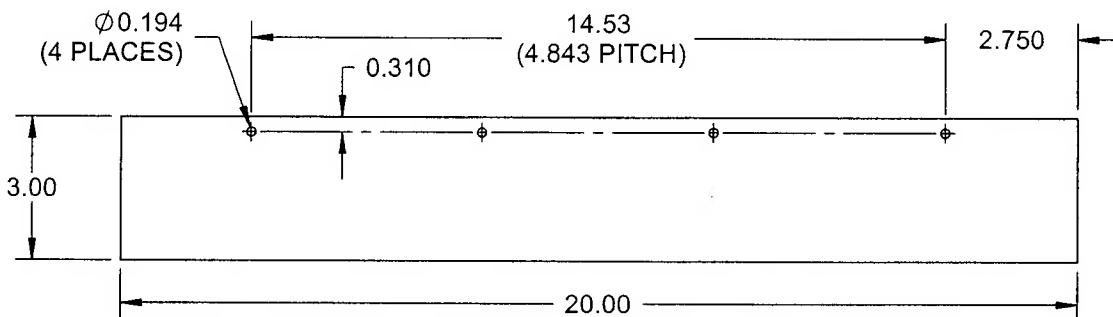
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER SCALE 1:4	



D3476-1 DUCT



D3476-1F DUCT FLAT PATTERN

NOTES:



- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

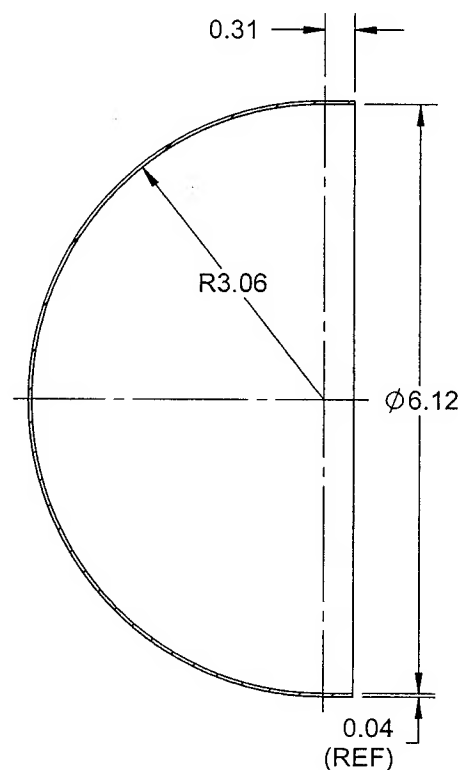
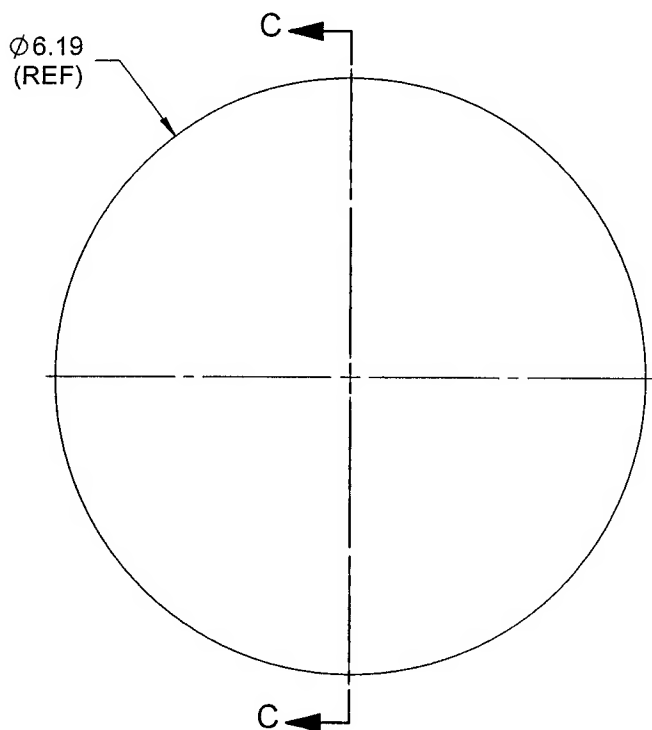
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2



SECTION C-C

D3476-3S DOME, SPINNING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING
OF MATERIAL.
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

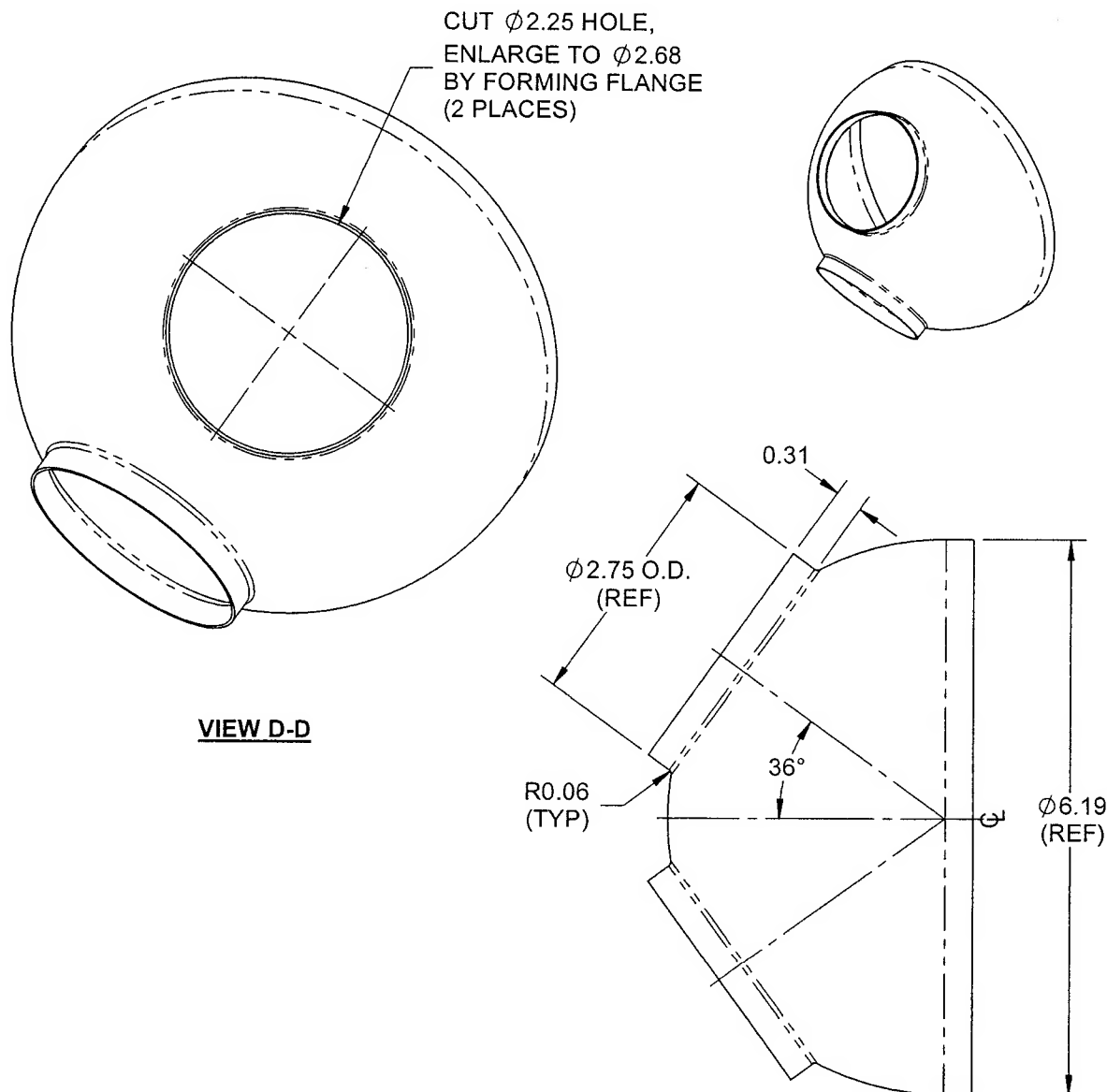
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	
		SCALE 1:2	



D3476 DOME

NOTES:

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

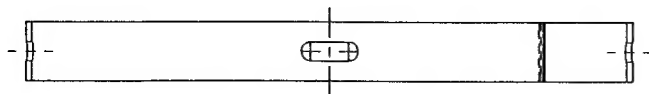
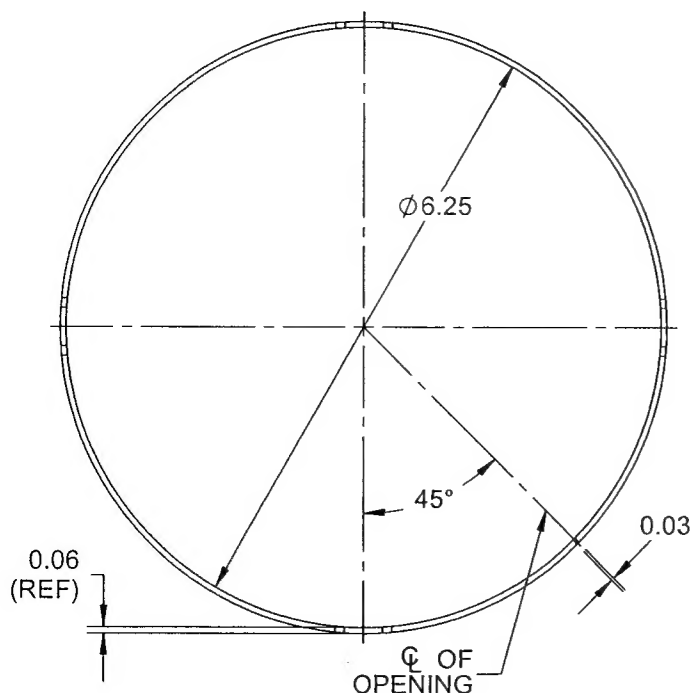
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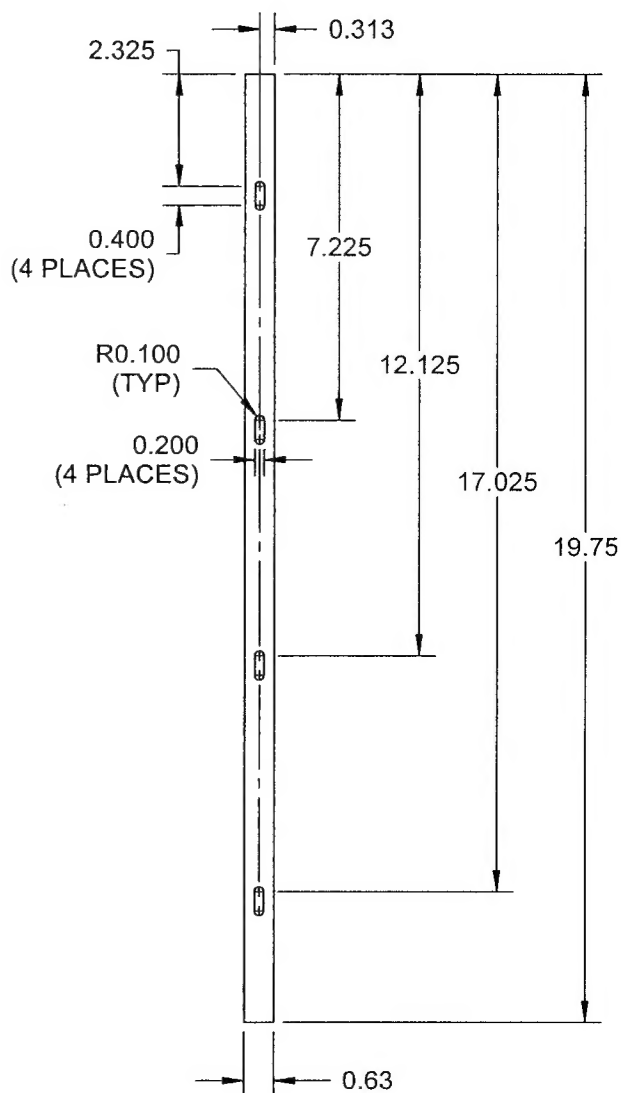
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D3476-5 SPACER-RING





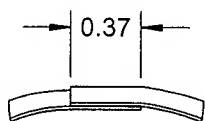
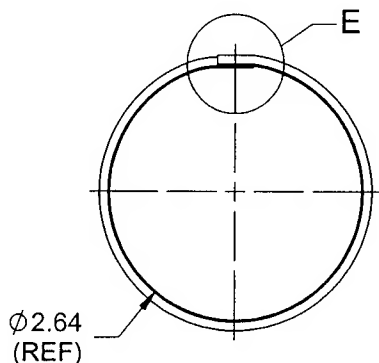
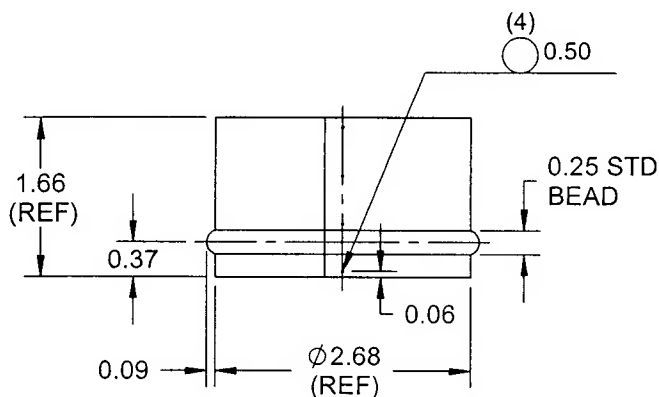
**D3476-5F SPACER-RING
FLAT PATTERN**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED)
2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: ELECTRO CHEMICALLY POLISH
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

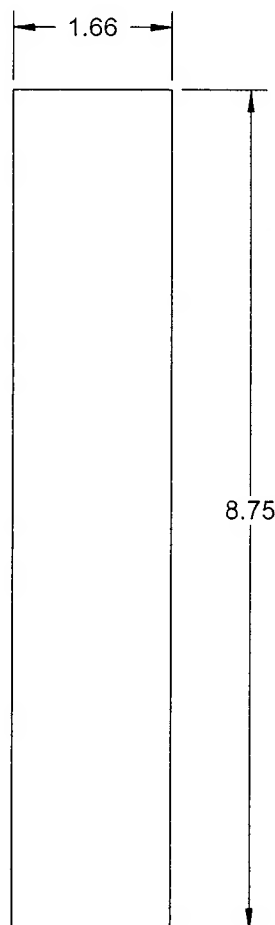
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2



DETAIL E
SCALE 1 : 1

D3476-7 TUBE



D3476-7 TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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